

Work Order ID 57550

April 8, 2010 9:21:48 AM



Page 1

Item ID: D3295-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Window

Start Date: 4/08/10 Start Qty: 8.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: W Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3295	Rev D

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3295 ☐ Dwg Rev: D ☐ Prog Rev: D ☐ 2-
Remove plastic and wrap in saran wrap. ☐ 2-Debur if necessary

B 10-4-14

(12)

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-4-14

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/14

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3295. ☐ Put window in plastic wrap.

Handwritten signature and date: 4/10/10

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Handwritten note: S. L. L. L. L.

Handwritten circled number: 12

150

0.00



Identify as per dwg & Stock Location

Handwritten number: 210

Packaging

Memo

0.00

Packaging

Handwritten signature and date: 10-4-26 SP

Handwritten circled number: 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Required Date: 4/16/10 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/27 *[Signature]*

MF 10-4-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

April 8, 2010 9:21:47 AM

Page 1

Work Order ID: 57550

Parent Item: D3295-041

Parent Item Name: Floor Window



Comments: IPP C05.06.20D3295-1 no longer made in-houseKJ/JLM
IPP Rev:D Added DT8822 07-03-20 JLM
IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

Start Date: 4/08/10

Required Date: 4/16/10

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2728-1		Manufactured	No			100	Each	0.0000	0.0000			
												
Dart Logo label												
MLEXS.125-9034-01		Purchased	No			140	sf	52.0000	10.4421	16.		
												
1/8" 9034 Lexan Sheet												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

106173

106403

52

20

32

106173

(12)

ES 10/04/17

16.

1810-4-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 57550
Description: Window		Part Number: D3295
Inspection Dwg: D3295	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	.161	*			
17.13	+/-0.030	17.13	*			
10.43	+/-0.030	10.43	*			
14.35	+/-0.030	14.35	*			
8.98	+/-0.030	8.98	*			
0.625	+/-0.010	.624	*			
7.109	+/-0.010	7.112	*			
15.845	+/-0.010	15.845	*			
2.308	+/-0.010	2.308	*			
5.420	+/-0.010	5.420	*			
9.402	+/-0.010	9.402	*			
1.312	+/-0.010	1.308	*			
6.260	+/-0.010	6.260	*			
12.520	+/-0.010	12.520	*			
0.313	+/-0.010	.317	*			
3.750	+/-0.010	3.750	*			
8.150	+/-0.010	8.152	*			
9.006	+/-0.010	9.009	*			
0.125	+/-0.010	.120	*			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-4-14	Date: 10/04/14	Date:	N/A

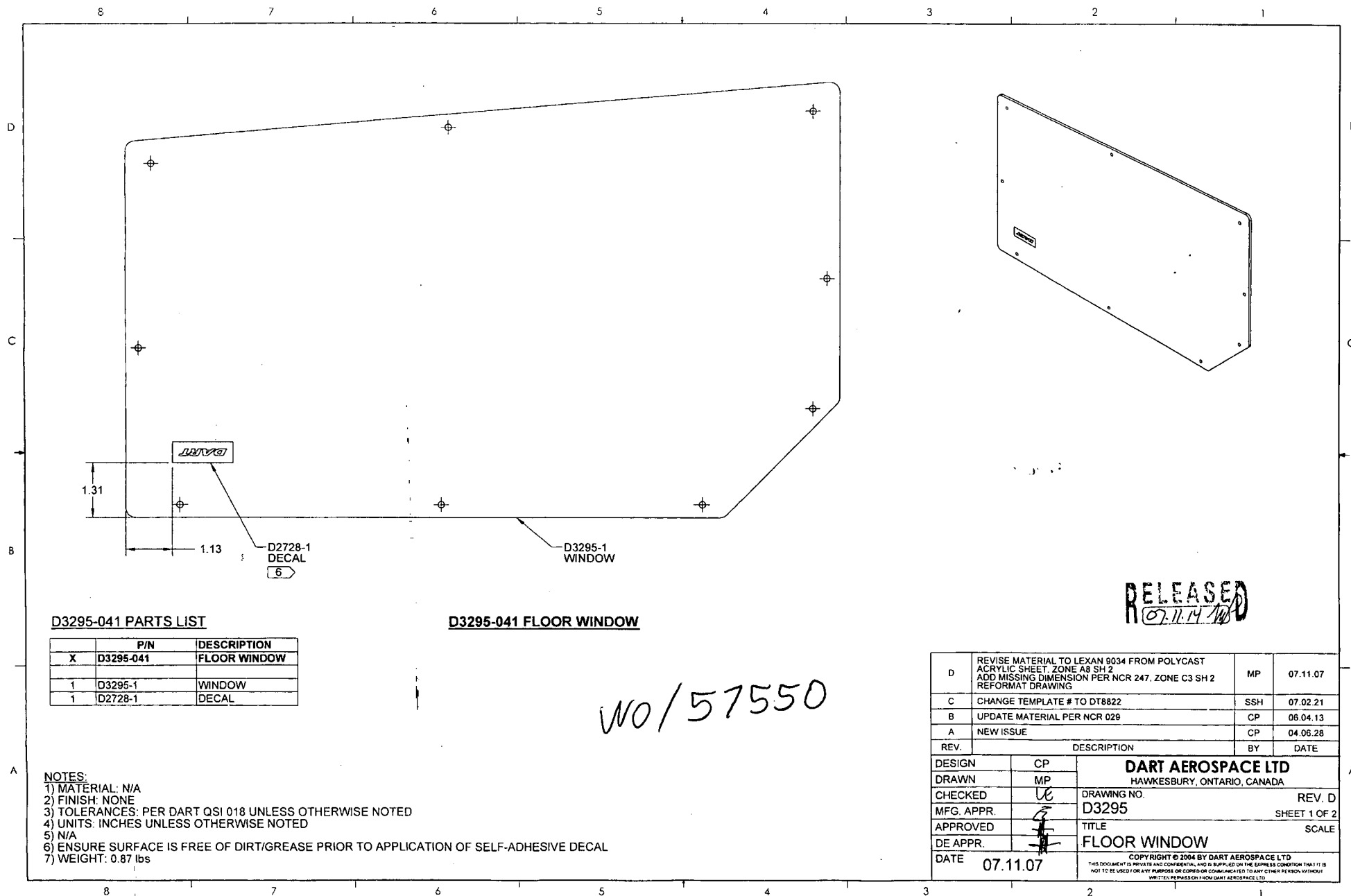
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3295-041	KJ/EC/DD	AS

Remember....

- Lean is war to WASTE.
- Waste is an activity or output that ***adds cost but does not add value***
- You have to get into a mindset of identifying and eliminating all wastes.

The 7 deadly wastes

- | | |
|--------------------------|------------------------------------|
| 1. Overproduction | 2. Rework |
| 3. Transportation | 4. Inappropriate / over Processing |
| 5. Unnecessary Inventory | 6. Delays / Waiting |
| 7. Unnecessary Motions | |



D3295-041 PARTS LIST

	P/N	DESCRIPTION
X	D3295-041	FLOOR WINDOW
1	D3295-1	WINDOW
1	D2728-1	DECAL

D3295-041 FLOOR WINDOW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) N/A
- 6) ENSURE SURFACE IS FREE OF DIRT/GREASE PRIOR TO APPLICATION OF SELF-ADHESIVE DECAL
- 7) WEIGHT: 0.87 lbs

W0/57550

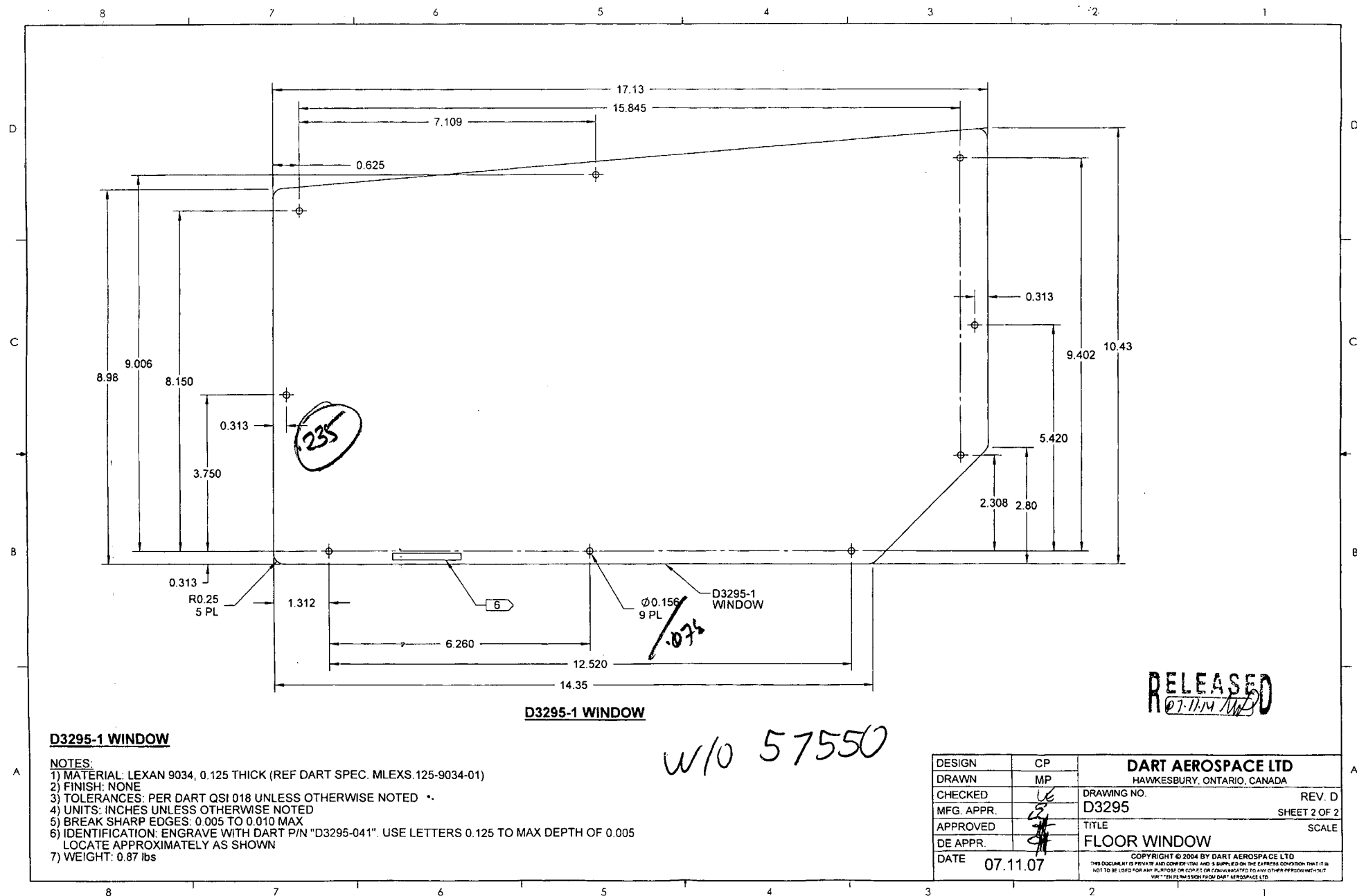
RELEASED
07.11.14

D	REVISE MATERIAL TO LEXAN 9034 FROM POLYCAST ACRYLIC SHEET, ZONE A8 SH 2 ADD MISSING DIMENSION PER NCR 247, ZONE C3 SH 2 REFORMAT DRAWING	MP	07.11.07
C	CHANGE TEMPLATE # TO DT8822	SSH	07.02.21
B	UPDATE MATERIAL PER NCR 029	CP	06.04.13
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED	UC	DRAWING NO.	REV. D
MFG. APPR.	E	D3295	SHEET 1 OF 2
APPROVED	J	TITLE	SCALE
DE APPR.	J	FLOOR WINDOW	
DATE	07.11.07	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



5S continued...

- **Standardize (Seiketsu) (清潔):** Standardizing. This refers to standardized work practices. This means operating in a consistent and standardized fashion. Everyone knows exactly what his or her responsibilities are.
- **Sustain (Shitsuke) (躰):** Sustaining. Refers to maintaining and reviewing standards. Once the previous 4S's have been established they become the new way to operate. Maintain the focus on this new way of operating, and do not allow a gradual decline back to the old ways of operating.



The following chart shows the repeatable 5S system.

5S Flow Chart

